



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4170-3
Job Sheet 173301



Part No: D4170-3

Job Qty: 20 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 3/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD IPP Rev:A 10.11.02 as per revB DD
verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		3/10/18	0.00	0.00	Start Up Machining-2		
100	Hardinge	20 pcs		3/12/18	0.00	4.65	Hardinge		
120	QC	20 pcs		3/12/18	0.00	0.00	QC8		
130	Packaging	20 pcs		3/12/18	0.00	0.00	Packaging3-2		
140	QC21-SA	20 Ea		3/12/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FA989 FOLIO REV: _____ DWG REV: _____ DEBURR
Descriptions: 120 - QC8- Inspect parts - second check
130 - Identify as per dwg & Stock Location: _____ *** STOCK IN STORES***
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	5.5000 ft (.275 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	6	49	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	3.150Inches + 0.030 - 0.000	3.180 3.150	Diameter	
2	Spacer	0.438Inches + 0.006 - 0.001	0.444 0.437	Diameter	
3	Spacer	0.322Inches + 0.006 - 0.001	0.328 0.321	Diameter	
4	Spacer	0.058Inches ± 0.010	0.068 0.048		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K8A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 03/19/18 Container No: S052540 Part: D4170-3 Job No: 173301 Serial No/Batch: S052540 Revision: _____ Inspector: _____		Lead hand / Supervisor Approval Verification																																																		
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-v ☐</td> <td>ss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operato. ☐</td> <td>igram ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td></td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td></td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td></td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Stock Pulled ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Out of Sequence ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Off-set ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Mislabeled ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Fit/Function ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td>Misaligned/off center ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> <td></td> </tr> </table>		Environment ☐	No Re-v ☐	ss/Surge ☐	Positioned Wrong ☐	Design ☐	Operato. ☐	igram ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐		Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐		Part Incorrect ☐	Handling/Pre ☐	Training ☐		Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Stock Pulled ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Out of Sequence ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Off-set ☐	Finish ☐	LOA ☐	Product Improvement ☐	Mislabeled ☐	Misread ☐	Substation ☐	Process Improvement ☐	Fit/Function ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misaligned/off center ☐		Misidentified ☐	Past Due ☐			OTHER : _____		
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